Dart Aerospace Ltd. Wednesday, 24/09/2008 12:47:56 PM Julie Lecocq (User: **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number : 42268 **Estimate Number** : 11633 Part Number : D2972 P.O. Number : D2972 REV A **Drawing Number** : 24/09/2008 S.O. No. : This Issue : N/A : NC **Project Number** Prsht Rev. : A : // : MACHINED PARTS **Drawing Revision** First Issue Type : 33544 Material **Previous Run** : 30/10/2008 Qty: 100 Um: **Due Date** Written By **Checked & Approved By** New Issue EC 00.05.18 Comment Est Rev:B Now Made In-House 07-07-19 JLM Verified By:EC **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** 303 Round Bar 1.00 M303R1000 1.0 10.6050 f(s) Comment: Qty.: 0.1061 f(s)/Unit Total: 303 Round Bar 1.0" Batch: <u>MID ) 7 (161</u> 2.0 HARDINGE Comment: 1-TURN AS PER FOLIO FA701 & DWG D2972, FOLIO REV: A DWG REV: 2-DEBURR AS REQUIRED 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 SECOND CHECK



5.0



Each

Comment: SECOND CHECK **PACKAGING 1** 

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:





## Dart Aerospace Ltd

<b>-</b> 4.17.10.	oopaoo	- Ltu								
W/O:	·		W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	By Date			Approval Chief Eng / Prod Mgr	Approval QC Inspector
							ļ			
Part No		PAR #:	Fault Cate	egory:	NCR: Y	es N	o DQA:		_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C	Clos	sed:		Date: _	
NCR:		V	ORK ORE	DER NON-CONFORMA	ANCE (N	CR)				
		Description of NC	Corrective Action Sec		on B	Verif		tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Verification Section C		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User: Wednesday, 24/09/2008 12:47:56 PM

Julie Lecocq

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: BUSHING** 

Job Number: 42268

Part Number: D2972

Job Number:



Seq. #:

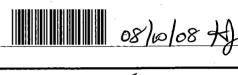
**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL IN SPECTION/W/O RELEASE

Job Completion



## **Dart Aerospace Ltd**

W/O:			WORK ORDER (	CHANGES	3					
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _			
	Resoluti	on:	Disposition:	QA: N/C	Closed:		Date:			

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
DATE		Description of NC		Verification	Annuarat	Approval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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				,						
							<u></u>			
		· .						4.		

NOTE: Date & initial all entries

Description: Bushing

Description Dwg: D2972

Rev: A

Work Order: 4208

Part Number: D2972

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.030 x 20°	+/-0.010 x +/-0.5°	°036150°	7		•	
R0.005 – 0.010	-	B-005-2010	7			
0.572	+/-0.010	.571	V			
0.118	+/-0.010	.\\6	<b>/</b>			
1.190	+/-0.010	1.188	<b>√</b>			
Ø0.787	+/-0.010	885.X	J			
Ø0.625	+/-0.010	0.626	$\int_{-\infty}^{\infty}$			
Ø0.472	+/-0.010	Ø 473				
Ø0.257	+0.006/-0.001	Ø .258	$\checkmark$			
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				1		

Measured by:	Audited by: HA	Prototype Approval:	N/A
Date: OBLICA	Date: 07/10/07	Date:	N/A

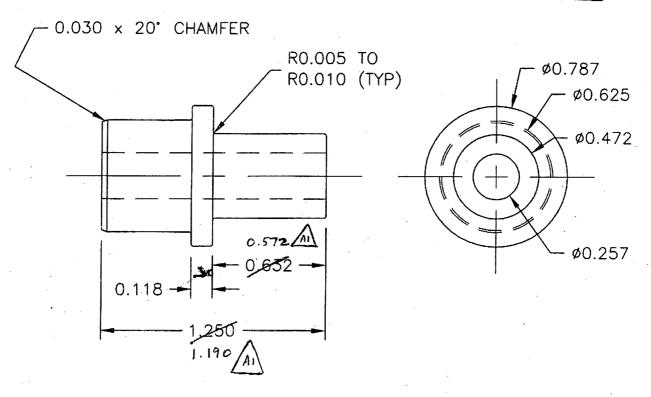
Rev	Date	Change	Revised by	Approved
Α	07.11.23	New Issue	KJ/EC/DD	<i>Y</i>





	DESIGN RF	DRAWN BY	DART AEROSPA	
1	CHECKED	APPROVED	DRAWING NO.	REV. A
	-	#	D2972	SHEET 1 OF 1
	DATE		TITLE	SCALE
	00.03.13		BUSHING	2:1
	Α	00.03.13	NEW ISSUE	





MATERIAL: AISI 303 STAINLESS STEEL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDIOP COPY RADIUS ALL INSIDE EDGES 0.005 TO 0.010 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 ALL DIMENSIONS ARE IN INCHES

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

01.03.12 REDUCE LENGTH OF BUSHING

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